



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4822-2

Job Sheet 169823



Part No: D4822-2

Job Qty: 5 ea

Part Name: Upper Right Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/27/17

Job Tracking No:

Due Date: 12/8/17

Created By: Sonia Plouffe

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 13-04-19 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		12/7/17	0.00	0.00	Start Up Machining		N/R
100	Bandsaw	5 pcs		12/8/17	0.00	1.22	Bandsaw1		N/R
110	Purchasing	5 pcs		12/8/17	0.00	0.00	Purchasing		AT 18/02/20
115	Packaging	5 pcs		12/8/17	0.00	0.00	Packaging2		AT 18/03/20
117	QC	5 pcs		12/8/17	0.00	0.00	QC6		38
120	Outsource	5 pcs		12/8/17			ATG001-VC		AT 18/03/20
122	QC	5 pcs		12/8/17	0.00	0.00	QC14		11
140	QC	5 pcs		12/8/17	0.00	0.00	QC5		21
170	Packaging	5 pcs		12/8/17	0.00	0.00	Packaging3		21
190	QC21-SA	5 Ea		12/8/17	0.00	0.00	QC21		21

Part Op 100 - CUT AT 32.00" LONG
 Descriptions: 110 - ISSUE P/O 1038259 POSSIBLE SUPPLIER: WEJAY ***1 BLANK MAKES 2 PARTS*** Certificate of conformaty required
 115 - Receive & Inspect for Damage & Mat'l Certs
 117 - QC6- All purchased or subcontracted products
 120 - Hard Anodize, Color Black and Prime as Per Dwg D4822 Rev. C
 122 - QC14- Inspect Spray Paint
 140 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4822-2P	Upper Right Deflector	5 pcs (1 ea)	110-Purchasing	5043671
M7075T6S4.000X4.000	7075-T6 Sheet 4.000" X 4.000" cut to size: 32" LONG	6.7500 ft (1.35 ea)	110-Purchasing	M131552

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D4822-2P	5	7	0
	M7075T6S4.000X4.000	7 6.75	13	7

Allocated Container Detail

Qty	Serial No	Location	Init
7	S043714	mat	

Upper Right Deflector

Serial No/Batch: S043949

Operation:

Packaging

Job No: 169823

Part Specifications
Specifications could not be found.

Plex 2/20/18 3:24 PM Dart.Gagnon.Michelle



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038259

Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038259
PO Date: 11/6/17
Due Date: 11/20/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items												Unit	Extended
Line Item	Part	Rev	Supplier Part No	Item No	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Price (CAD)	Price
1	D4970-3P				Windshield Deflector - Upper As per Dwg D4970 Rev. C		Firmed	11/20/17	2 Ea	0 Ea	2 Ea	\$1,095.00/Ea	\$2,190.00
Line Item Note job# 167748													
2	D4822-1P				Upper Deflector, LH As per Dwg D4822 Rev. C		Firmed	11/20/17	10 pcs	0 pcs	10 pcs	\$1,057.00/pcs	\$10,570.00
Line Item Note JOB# 167749													
3	D4822-2P				Upper Right Deflector As per Dwg D4822 Rev. C		Firmed	11/20/17	8 pcs	0 pcs	8 pcs	\$1,057.00/pcs	\$8,456.00
Line Item Note job # 167750													
4	D4821-1P				Windshield Deflector As per Dwg D4821 Rev. B		Firmed	11/20/17	8 pcs	0 pcs	8 pcs	\$1,095.00/pcs	\$8,760.00
Line Item Note job# 16751													
												Grand Total: \$29,976.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

Plex 11/6/17 11:53 AM dart.baker.diane



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: Feb. 5, 2018	
		P.O.# PO38259 item 3	
		WEJAY JOB# 38873A	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4822-2P 'Upper Right Hand Deflector' Job Number: 167750	5	Machined complete per drawing req'ts.	D4822 / rev. C
Note: 1) Material supplied by Dart Aerospace: for qty 5 parts ref. DART Batch# M131552. 2) 1st Article Inspection Report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith
Authorized Q.A. Signatory

SECTION E-E
SCALE 2X

SECTION F-F
SCALE 2X

VIEW D-D
SCALE 1X

D4822-2 UPPER DEFLECTOR RH

RELEASED

2011 FEB 25 #P

NOTES:

- 1) MATERIAL: 7075-T6 (OR T851/T8510/T8511/T852) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4122/4123/4180/487) OR
PER AMS-QQ-A-200/11 (REF DART SPEC. M7075T85)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625F TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS III, 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4822-2", AGUSTA WESTLAND P/N "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE,
USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 1.22 LBS (0.6 KG)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4822-2-01GES (D4822-2-01STEP)

APPROVED	DESIGN	DB	DART AEROSPACE LTD	
	DRAWN	YS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	DC	DRAWING NO. D4822	REV. C
	MFG. APPR.	EPDMA	SHEET 3 OF 3	
	APPROVED	HS	SCALE	
	DE APPR.	DS	TITLE UPPER DEFLECTOR	
	DATE	14.02.04	NTS	



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 38873

PAGE: 1 of 1

CUSTOMER: Dart Aerospace

CUST. P.O.# 38259 - ITEM 3

PART No. D4822-2

DESCRIPTION: Deflector Right Hand

DWG No. D4822

REV. C

E.C.O. -

MATERIAL: DART BATCH #M131552

INSPECTOR: [Signature]

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: -

N.C.R.# -

DATE:

FEB 5, 2018

WMP
03

INSTRUCTIONS, COMMENTS: Standard Tolerances per DART QSI 018 unless otherwise noted

- 1ST ARTICLE INSPECTION -

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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1	47°	View D-D	±.5°	3/B5	46.5°	1	Acc.
2	83°		±.5°	3/B2	82.5°	1	Acc.
3	R 0.38" typ.		±.03	3/B1	R.375 TYP.	1	Acc.
4	3.30"		±.03	3/C5	3.305	1	Acc.
5	0.79" typ.		±.03	3/B1	.795-.798	1	Acc.
6	2.47		±.03	3/B3	2.464-2.475	1	Acc.
7	R 0.13 typ.		±.03	3/C4	R.125-.130	1	Acc.
8	29.29"		±.03	3/C3	29.280	1	Acc.
9	R0.50" typ	Section E-E	±.03	3/D5	R.500 TYP.	1	Acc.
10	Ø0.206 hole thru		+0.005/-0.001	3/D1	.207-.2098	1	Acc.
11	2.441"		±.010	3/D4	2.443	1	Acc.
12	3.256" typ.		±.010	3/D4	3.255-3.258	1	Acc.
13	0.65" typ.		±.03	3/D5	.653-.655	1	Acc.
14	0.157"		±.01	3/D6	.1605-.162	1	Acc.
15	R0.13" typ. e-model is .200"R		±.03	3/D7	R.200 TYP.	1	Acc.
16	.099"		±.01	3/D7	.096-.098	1	Acc.
17	1.04"	Section F-F	±.03	3/D8	1.046-1.048	1	Acc.
18	1.87"		±.03	3/C7	1.868-1.869	1	Acc.
19	0.236"		±.01	3/C7	.233-.2355	1	Acc.
20	0.157"		±.01	3/B6	.1605-.162	1	Acc.
21	2.01"		±.03	3/B7	2.005-2.007	1	Acc.
22	1.04"		±.03	3/B8	1.046-1.048	1	Acc.
23	R0.13" typ. e-model is .200"R		±.10	3/B7	R.200 TYP.	1	Acc.
24	Deburring	Per note 5	.005-.010	3/A8	PASSED	1	Acc.
25	Identification	Per note 6		3/A8	TAGGED WITH PART# * DART JOB No.	1	Acc.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039091

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039091
PO Date: 2/22/18
Due Date: 3/1/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
FEB 28 2018

Items				Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Line Item	Job	Part	Description							
1	167749	D4822-1	Upper Deflector, LH HARD ANODIZE IAW MIL-A- 8625 TYPE 3 COLOUR BLACK PRIME AS PER DWG D4821 REV. B	Firmed	3/1/18	10 pcs	0 pcs	10 pcs	\$31.45/pcs	\$314.50
						✓ 10x		AT 18/03/09		
2	169823	D4822-2	Upper Right Deflector Hard Anodize, Color Black and Prime as Per Dwg D4822 Rev C	Firmed	3/1/18	5 pcs	0 pcs	5 pcs	\$31.45/pcs	\$157.25
						✓ 5x		AT 18/03/09		
3	172047	D5155-043	Co-Pilot Collective Head Assembly (212/412) Anodize Black as per Dwg D5155 Rev. B	Firmed	3/1/18	2 pcs	0 pcs	2 pcs	\$6.25/pcs	\$12.50
						✓ 2x		AT 18/03/08		
4	170452	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	3/1/18	12 pcs	0 pcs	12 pcs	\$12.10/pcs	\$145.20
						✓ 12x		AT 18/03/08		
5	171985	646.3313	Upper Guide Issue P/O to ATG : Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed	3/1/18	20 pcs	0 pcs	20 pcs	\$14.55/pcs	\$291.00
						✓ 20x		AT 18/03/08		
6	168292	647.1712	Gusset Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 647.1700 Rev. E	Firmed	3/1/18	4 pcs	0 pcs	4 pcs	\$14.10/pcs	\$56.40
						✓ 4x		AT 18/03/02		
		171188		Firmed	3/1/18	16 pcs	0 pcs	16 pcs	\$14.10/pcs	\$225.60
						✓ 16x		AT 18/03/02		
Sub Total:						20	0	20		\$282.00
7	169389-A	647.7821	Eye Bolt Fitting LH Issue P/O to ATG : 1- Black	Firmed	3/1/18	4 pcs	0 pcs	4 pcs	\$10.50/pcs	\$42.00
						✓ 4x		AT 18/03/08		



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914736

Date: 07-Mar-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
<i>Spcs</i> <i>M/L</i> <i>9/63/18</i>	Part: D4822-2 Upper Right Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing. Job: 22578	Rev: C	PO: PO039091 Line: 2
20 ea	Part: 646.3313 Upper Guide Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22581	Rev: A	PO: PO039091 Line: 5
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>07/03/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			